

Work Order ID 63859

November 17, 2010 8:28:29 AM

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Item ID: D3608-3

Revision ID:

Item Name: Upper Doubler

Start Date: 11/17/10 Start Qty: 1.00

Required Date: 11/17/10 Req'd Qty: 1.00

Reference:

Approvals:

Process Plan: *u*

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3608

PC1

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3608

Dwg Rev: *PC1*

Prog Rev: *PC1*

2-Deburr if necessary

B10-11-17

①

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B10-11-17

120

QC8- Inspect parts - second check

0.00 - inspect to PC1



QC

Memo

0.00

Quality Control

Day only
Solving 70

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Item ID: D3608-3

Accept

Revision ID:

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Approvals: Process Plan: Date:

QC: Date:

Tooling: Date:

SPC (Y/N): Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

150

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

Ship to Eagle Harvey

0.00

Packaging

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

U 10-11-17

ENG 1106

U 10-11-17

10/11/23

POSITIVE RECALL

EFFECTIVE *10-11-17* AUTH *U*

RELEASED *11* DATE *10-11-22*

Picklist Print

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Work Order ID: 63859

Parent Item: D3608-3

Parent Item Name: Upper Doubler



Start Date: 11/17/10

Required Date: 11/17/10

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New Issue 07-03-26 JLM
 IPP Rev:B 08-10-15 preliminary issue DD verified by:EC
 IPP Rev:C 08-12-11 rev.A as per dwg DD verified by:EC IPP
 Rev:D 10.02.16 rev.B as per dwg DD verified by:EC IPP Rev:E
 10.11.17 as per PC1 dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA		Purchased	No			100	sf	109.3000	0.7392	0.778105			



304/316 .040 Sheet



11-11-17

Location	Loc Qty	Loc Code
MAT	105.3	
115762	10.2	
115953	95.1	
MAT20	4	
113062	1.398	
115440	2.602	

115953

①

DART AEROSPACE LTD		Work Order: 63859
Description: Upper Doublee		Part Number: D3608-3
Inspection Dwg: D3608-3 . Rev: PC1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

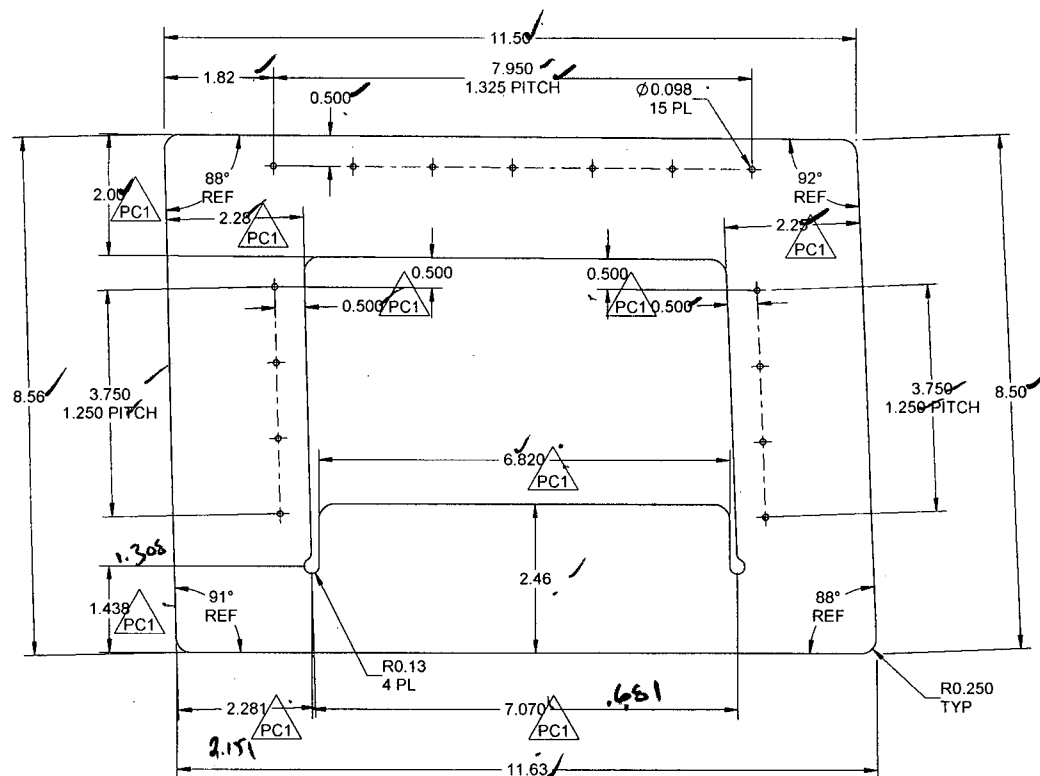
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .098	+ .004 - .001	.101	X		V IB02	
1.82	± .020	1.808	X		V	
.500	± .010	.499	X		V	
7.950	± .010	7.942	X		V	
1.325	± .010	1.324	X		V	
11.50	± .020	11.499	X		V PRO IB02	
2.25	± .030	2.251	X		V	
3.750	± .010	3.746	X		V	
1.250	± .010	1.247	X		V	
8.50	± .030	8.503	X		V PRO IB02	
2.46	± .030	2.463	X		V	
7.010	± .010	7.073	X		V	
2.281	± .010	2.284	X		V	
11.63	± .030	11.621	X		V PRO IB02	
6.820	± .010	6.820	X		V	
1.438	± .010	1.438	X		V	
2.00	± .030	2.004	X		V	
8.56	± .030	8.559	X		IB PRO IB02	
.038	± .010	.036	X		V	

Measured by:	IB
Date:	10-11-17

Audited by:	S
Date:	10/11/17

Prototype Approval:	
Date:	




Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



D3608-3 UPPER DOUBLER

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 20 GAUGE
PER MIL-S-5059, OR AMS 5513 (304) OR AMS 5524 (316)
OR ASTM A240 OR ASTM SA240
REF DART SPEC M304SS20GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.75 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PC
MFG. APPR.		D3608	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		DOUBLER	NTS
DATE	10.11.15	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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